

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014483**Date Inspected:** 25-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena, Bnifacio Daquina, GWS Prasad, Jayab			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	SAS OBG		

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 2W/3W-C, 5E/6E-A and the following observations were made:

5E/6E-A

Upon the arrival of the QA Inspector, it was observed the above identified complete joint penetration groove weld had been previously completed. It was noted no grinding appeared to have been performed on the weld reinforcement. The QA Inspector noted, it appeared some weld repairs had been made previously to correct some under filled areas of the weld. It was noted no work was performed on the above identified weld joint on the QA Inspectors shift. The QA Inspector noted American Bridge/Fluor (ABF) appeared to be setting up to perform submerged arc welding (SAW) welder qualification tests in the welding connex directly over the 5E/6E-A weld joint.

The QA Inspector randomly observed multiple areas which appeared to have unacceptable under fill. The QA Inspector informed the ABF engineer John Callaghan of the issue. Mr. Callaghan informed the QA Inspector to meet with the SE QC Inspector Tony Sherwood who is assigned to the above identified weld joint, and inform him of the issues. The QA Inspector informed the QC Inspector Tony Sherwood of the under filled areas of the weld joint. Mr. Sherwood informed the QA Inspector he was aware of the areas and additional welding would be performed. The QA Inspector noted the QC Inspector indicated the areas with a distinguishing marking directly on the material.

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2W/3W-C

Upon the arrival of the QA Inspector it was observed the above identified weld joint appeared to be approximately 80% complete. The QA Inspector randomly observed the ABF welder was setting up the flux cored arc welding (FCAW) machine to complete the top 300mm of the weld joint where the side plate meets the corner plate. The QA Inspector randomly observed the ABF welder Song Tao Huang had previously started the induction Heating blankets to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker and noted the minimum required preheat had been achieved. The QA Inspector randomly observed the SE QC Inspector identified as Bernard Docena set the FCAW machine to the parameters of the approved WPS. The QA Inspector randomly observed the FCAW parameters were 247Amps 24Volts and a travel speed of 300mm/min. The QA Inspector randomly observed the ABF welder Song Toa Huang begin the FCAW fill pass in the bottom 2400mm of the above identified weld joint. The QA Inspector noted the root and “hot” pass was completed on the previous day shift. The QA Inspector randomly observed the ABF welder performing the FCAW fill pass for the remainder of the shift.

The QA Inspector spent the remainder of the shift researching and updating the ABF production welding tracking chart and logbook.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
